CLAIMS

What is claimed is:

1. A method of making a refrigerator storage assembly comprising:

feeding a material to an extruder, wherein the material is selected from a metal or a polymeric composition;

extruding the material through a die of the extruder to form a first intermediate extrusion, wherein the die includes an aperture defining a first leg and a second leg;

cutting the first intermediate extrusion to a predetermined length to form a first shelf extrusion having a bottom wall integrally formed with a side wall; and

attaching a first pair of end walls to the ends of the first shelf extrusion, wherein each of the first pair of end walls engages the bottom wall and the side wall of the first shelf extrusion and wherein each of the first pair of end walls includes a distal face having a bracket formed therein for engaging a support disposed in a refrigerator.

2. The method of claim 1, further comprising aligning a wall section in a channel formed in the side wall of the first shelf extrusion and engaging the ends of the wall section with the first pair of end walls.

3. The method of claim 2, further comprising disposing a cap over the wall section and engaging the ends of the cap with the first pair of end walls.

4. The method of claim 1, further comprising injection molding each of the first pair of end walls.

5. The method of claim 1, wherein attaching the first pair of end walls to the ends of the first shelf extrusion includes engaging the first shelf extrusion and one of the first pair end walls with a fastener.

6. The method of claim 5, wherein the fastener is a screw threadably engaged with the first shelf extrusion and one of the first pair of end walls.

7. The method of claim 1, further comprising coating the first shelf extrusion.

8. The method of claim 7, wherein the step of coating comprises a step selected from painting and plating.

9. The method of claim 1 further comprising:

forming a second intermediate extrusion by extruding the material through the die;

cutting the second intermediate extrusion to a second predetermined length to form a second shelf extrusion, wherein the first predetermined length is unequal to the second predetermined length; and

attaching a second pair of end walls to the ends of the second shelf extrusion.

10. The method of claim 9, further comprising coating the second shelf extrusion.

11. The method of claim 10, wherein the step of coating comprises a step selected from painting and plating.

12. A method for forming a refrigerator storage assembly comprising:

feeding a material to an extruder;

extruding the material through a die of the extruder to form a first intermediate extrusion;

cutting the first intermediate extrusion to a first predetermined length to form a first shelf extrusion;

injection molding a first pair of end walls, wherein each of the first pair of end walls includes a bracket formed on a distal face thereof for engaging a support in a refrigerator;

attaching the first pair of end walls to the ends of the first shelf extrusion;

forming a second intermediate extrusion by extruding the material through the die;

cutting the second intermediate extrusion to a second predetermined length to form a second shelf extrusion, wherein the first predetermined length is unequal to the second predetermined length; and,

attaching a second pair of end walls to the ends of the second shelf extrusion, wherein each of the second pair of end walls includes a bracket for engaging a support in a refrigerator.

13. The method of claim 12, wherein the material is a polymeric composition selected from polyvinyl chlorides, polycarbonates, polyesters, chlorinated polyethylenes, acrylics, polystyrenes, acrylonitrite-butadiene-styrene copolymers, nylons and combinations thereof.

14. The method of claim 13, wherein the material is a metal selected from aluminum, copper and steel

15. The method of claim 12, further comprising aligning a wall section in a channel formed in the first shelf extrusion and engaging the ends of the wall section with the first pair of end walls.

16. The method of claim 15, further comprising disposing a cap over the wall section and engaging the ends of the cap with the first pair of end walls.

17. The method of claim 12, wherein attaching the first pair of end walls to the ends of the first shelf extrusion includes engaging the first shelf extrusion and one of the first pair end walls with a fastener.

18. The method of claim 17, wherein the fastener is a screw threadably engaged with the first shelf extrusion and one of the first pair of end walls.

19. The method of claim 12, wherein one of the first pair of end walls is substantially identical to one of the second pair of end walls.

20. The method of claim 12, further comprising coating the first intermediate extrusion.

21. The method of claim 20, wherein the step of coating comprises a step selected from painting and plating.

22. The method of claim 20, further comprising coating the second intermediate extrusion.

23. The method of claim 22, wherein the step of coating comprises a step selected from painting and plating.

24. A method of making removable refrigerator storage assemblies comprising:

feeding a material to an extruder, wherein the material is selected from a metal or a polymeric composition;

extruding the material through a die of the extruder to form a first intermediate extrusion, wherein the die includes an aperture defining a first leg and a second leg;

cutting the first intermediate extrusion to a predetermined length to form a first shelf extrusion having a first bottom wall integrally formed with a first side wall;

injection molding a first and a second pair of end walls, wherein each of the first and second pairs of end walls includes a distal face having a bracket formed therein for engaging a support disposed in a refrigerator;

attaching the first pair of end walls to the ends of the first shelf extrusion, wherein each of the first pair of end walls engages the first bottom wall and the first side wall of the first shelf extrusion;

forming a second intermediate extrusion by extruding the material through the die;

cutting the second intermediate extrusion to a second predetermined length to form a second shelf extrusion, wherein the first predetermined length is unequal to the second predetermined length, and wherein the second shelf extrusion has a second bottom wall integrally formed with a second side wall; and

attaching the second pair of end walls to the ends of the second shelf extrusion, wherein each of the second pair of end walls engages the second bottom wall and the second side wall of the second shelf extrusion.

25. The method of claim 24, wherein the polymeric composition is selected from polyvinyl chlorides, polycarbonates, polyesters, chlorinated polyethylenes, acrylics, polystyrenes, acrylonitrite-butadiene-styrene copolymers, nylons and combinations thereof.

26. The method of claim 24, wherein the metal is selected from aluminum, copper and steel.

27. The method of claim 24, further comprising aligning a wall section in a channel formed in the first shelf extrusion and engaging the ends of the wall section with the first pair of end walls.

28. The method of claim 27, further comprising disposing a cap over the wall section and engaging the ends of the cap with the first pair of end walls.

29. The method of claim 24, wherein attaching the first pair of end walls to the ends of the first shelf extrusion includes engaging the first shelf extrusion and one of the first pair end walls with a fastener.

30. The method of claim 29, wherein the fastener is a screw threadably engaged with the first shelf extrusion and one of the first pair of end walls.

31. The method of claim 24, wherein one of the first pair of end walls is substantially identical to one of the second pair of end walls.

32. The method of claim 24, further comprising coating the first shelf extrusion.

33. The method of claim 32, wherein coating comprises a step selected from painting and plating.

34. The method of claim 32, further comprising coating the second shelf extrusion.

35. The method of claim 34, wherein coating comprises a step selected from painting and plating.